Work Order ID 54730 -

December 17, 2009 11:34:45 AM



Page 1

D3929-042 Accept Setup Start Item ID: **Revision ID:** Stop Item Name: Gusset Assembly Start Qty: 6.00 Cust Item ID: Start Date: 17/12/2009 Required Date: 23/12/2009 Req'd Qty: 6.00 **Customer:** Reference: Start Run Date: Approvals: Stop SPC (Y/N): Date: Date: Reject Accept Draw . Draw Plan Reject Insp. Sequence ID/ Operation Set Up/ Code Qty Qty Number Stamp Number .- Rev.-**Run Hours** Work Center ID Description **Revision Nbr** Draw Nbr D3929 Α 0.00 100 1B 10-1-4 0.00 Waterjet Memo 1-Cut as per Dwg D3929 FLOW CNC Wateriet Dwg Rev:_ Prog Rev: 2-Deburr if necessary QC2- Inspect parts off machine FAI/FAIB 0.00 110 0.00 QC Memo

Quality Control

	- That								
W/O:		· · · · · · · · · · · · · · · · · · ·	WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cate	_ NCR: Yes	No DQ	DQA: Date:			
Resolution:			Disposition	Disposition: QA				Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC			Section B Ver			ification Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	Approval QC Inspector
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December 17, 2009 11:34:45 AM

Item ID:

D3929-042

Accept

Setup Start

Stop



Revision ID:

Item Name:

Gusset Assembly

Start Date: 17/12/2009 **Required Date: 23/12/2009**

Start Oty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Run



Reference:

Approvals:

Process Plan:

Date: _____

Date:

Tooling:

0.00

0.00

SPC (Y/N):

Date: Date:

Stop

Start

Sequence ID/ **Work Center ID**

120

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

Set Up/ Run Hours Draw Number

Plan Draw Code Rev.

Accept Qty

Reject Reject Insp.

Qty Number Stamp

130

Packaging

Pick Kit

0.00

0.00

10-01.05

Packaging

140

Large Fab

Large Fab

0.00

0.00

Weld bushings D3907-1 as per dwg D3929

316L rod batch M1 09213

PD (0.01.05



W/0:54730		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector			
	140	6 parts on this who + 3 parts on -2 who				1				
		who was split due to extras were made	8	10/01/06	16	4.2.4.				
F						- · ·				
					:					

Part No: <u>D3929-042</u>	PAR #: Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	T	Description of NC		Corrective Action Section B		Verification		Annroyal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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Work Order ID 54730



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December 17, 2009 11:34:45 AM

Required Date: 23/12/2009

Item ID:

D3929-042

Accept

Setup Start

Stop



Revision ID:

Item Name:

Gusset Assembly

Start Date:

17/12/2009

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: _____

Tooling:

0.00

0.00

SPC (Y/N):

Date:

Run

Qty

Start

Stop



Sequence ID/ Work Center ID

150

Quality Control

Operation **Description**

OC9- Inspect visual per QSI004- Fusion Welds

Memo

Set Up/ **Run Hours**

Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Reject

Insp. Number Stamp

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

St 10/01/06 (6x



Dart Aerospace Ltd WORK ORDER CHANGES W/O: **Approval** Approval DATE STEP PROCEDURE CHANGE Ву Qty Chief Eng / Date QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR:

		Description of NC		Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
NOTE: D	ate & initi	al all entries	*		•	•		•	

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December 17, 2009 11:34:45 AM

Item ID:

D3929-042

Revision ID:

Gusset Assembly Item Name:

Start Date:

17/12/2009 . Start Qty: 6.00

Required Date: 23/12/2009 Req'd Qty: 6.00

Accept



Setup Start



Stop

Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Date:

Tooling:

Date: Date:

Run

Start

Stop

Sequence ID/ **Work Center ID**

180

QC21- Final Inspection - Work Order Release

Memo

Set Up/ **Run Hours** 0.00

SPC (Y/N):

Draw Number Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Quality Control

0.00

W/O:			WORK ORDER CHANGES							
DATE	STEP	P	ROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr **	Approval QC Inspector		
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Part No):	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date:			
	i	Resolution:	Disposition:	QA: N/C (Closed:		Date: _			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B				Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	QC Inspecto				
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Page 1

Work Order ID: 54730

Parent Item:

D3929-042

Parent Item Name: Gusset Assembly

Manufactured

No

Comments:



Start Date: 17/12/2009

Required Date: 23/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	≪Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M304S11GA		Purchased	No			100	sf	107.0791	2.8421	4.3	1819-1	-4

304/316 0.125 Sheet

Loc Code Warehouse Loc Qty Location Main Warehouse MAT 107.0791 112663 107.0791 112663 12.0000 130 57.0000 Each

D3907-1

Bushing

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
ST	17		
53673	17		SX PN
Main Warehouse			
WA	40	•	
54042	40		Jx 61

10.01.05

7 PD 10.01.05

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval** Approval **STEP** DATE PROCEDURE CHANGE By Qtv Chief Eng / Date QC Inspector Prod Mgr Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ___ **WORK ORDER NON-CONFORMANCE (NCR)** NCR: **Corrective Action** Section B **Description of NC** Verification **Approval** Approval DATE **STEP** Sign & **Action Description** Initial Section A Section C QC Inspector Chief Eng Chief Eng Date Chief Eng

DART AEROSPACE LTD	Work Order:	54730
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Protot

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension	<u> </u>		inspection	
Ø0.375	+0.006/-0.001	13/2	1-			
0.500	+/-0.010	501	×			_
0.500	+/-0.010	- 503	>			
4.036	+/-0.010	4.040	7			
4.382	+/-0.010	4,385	عز			
8.274	+/-0.010	४.३७७	<u>مر</u> ح			
10.915	+/-0.010	10.911	مح			
1.000	+/-0.010	1.007	٧	<u> </u>		
11.198	+/-0.010	11.300	>			
0.500	+/-0.010	,505	<u>></u>			
1.572	+/-0.010	1.573	<u>*</u>			
0.125	+/-0.010	117	R			
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	-					

Measured by:	B	Audited by:	2	Prototype Approval:	N/A
Date:	10-1-4	Date:	10/01/04	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	09.05.27	New Issue	P/O D3929-041/-042	KJ 👯	

Dart Aerospace Ltd

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٧	V/O:			W	ORK ORDER CHAN	NGES				<u> </u>		
	DATE	STEP	PROCEDURE CHANGE				Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval •QC Inspector	
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Part No:		•	PAR #:	Fault Cate	egory:	NCR: Yes No DQA:			↓ \ :	Date:		
				,	Disposition: QA							
١	CR:			WORK ORD	ER NON-CONFOR	MANCE (NCR)					
DATE STEP		STEP	Description of NC		Corrective Action Section B			Verification		Approval	Approval	
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D3929-042 GUSSET ASSEMBLY D3929-041 GUSSET ASSEMBLY

QTY -042 QTY -041 DESCRIPTION ITEM P/N D3929-041 **GUSSET ASSEMBLY** 2 X D3929-042 **GUSSET ASSEMBLY** BUSHING D3907-1 11 D3929-1 SUPPORT GUSSET 12

2

NEW ISSUE 09.04.03 Α BY DATE REV. DESCRIPTION DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D3929 MFG. APPR. SHEET 1 OF 3 TITLE SCALE APPROVED **GUSSET ASSEMBLY** NTS DE APPR. COPYRIGHT © 2009 BY DART AEROSPACE LTD

Indidocument is provide and confidential and is surrigion the Primess condition that if is
until to lecuse for with Particle or confidence communication for my other pressory without
with the repressory from but it arcospace to it. DATE 09.04.03

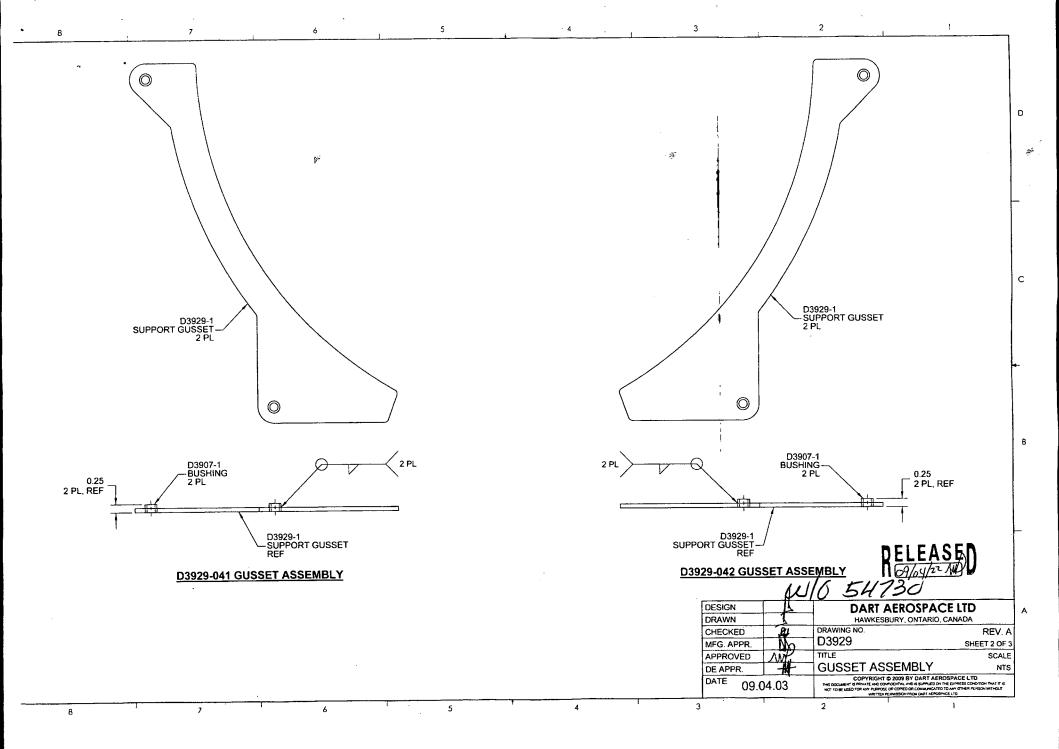
NATERIAL: N/A) FINISH: N/A 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
1) UNITS: INCHES UNLESS OTHERWISE NOTED
3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 3) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER ') WEIGHT: 0.73 lbs EACH 3) WELDING: PER DART QSI 004

5

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W/O:			WORK ORDER CHANGES						
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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	E L J								
		PAR #:	PAR #: Fault Category:		es No DQ	A:	Date:		
		n:	Disposition:	QA: N/C		Date:			
NCR:			WORK ORDER NON-CONFORMANCE (NCR)						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Chief Eng	QC Inspecto			
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Dart Ae	rospace	Ltd					•			,
W/O:			WO	RK ORDER CHA	NGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect	
				,						
Part No):	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition: 0			QA: N/C Closed: Date:				
NCR:			WORK ORDE	ER NON-CONFOI	RMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descript Chief Eng	Section B	Sign &		cation ion C	Approval Chief Eng	Approva QC Inspect

2.780 **-** 0.250 -- 1.572 D 0.500 45° R0.50 2 PL R12.00 10.915 1.000 11.198 TYP R0.13 TYP Ø0.375^{+0.005}-0.000 2 PL `70° REF 0.500 - 0.500 4.036 4.382 **D3929-1 SUPPORT GUSSET** DESIGN DART AEROSPACE LTD NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 11 GAUGE (0.125 THICK) REF. DART SPEC. M304S11GA HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D3929 MFG. APPR. SHEET 3 OF 3 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED TITLE SCALE APPROVED **GUSSET ASSEMBLY** NTS DE APPR. 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 3) IDENTIFICATION: N/A COPYRIGHT © 2009 BY DART AEROSPACE LTD
THIS DOCUMENT IS REVIEW AND CONTROL AND IS SUPPLED ON THE LEYERS SCHOPTION THAT IT IS
NOT TO BE USED FOR ANY PLARFORD OF COMPLICATE ON THE WITHOUT WHITTHEN HERBISCON FROM DART AEROSPACE LTD. DATE 09.04.03

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7) WEIGHT: 0.72 lbs

												
W/O:			WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			11 1 88 TAFFEF T R. 10 America									
Dowt No.	_	D. D. D. W.	- " - "									
			Fault Category:									
					QA: N/C Closed: Date:							
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DATE	I	Description of NC Section A	Corrective Action Section			Ver	Verification	Approval	Approval			
DATE	SIEP		Initial Chief Eng	Action Description Chief Eng	Sig Da	n& ∣ _S ,	ection C	Chief Eng	QC Inspecto			
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